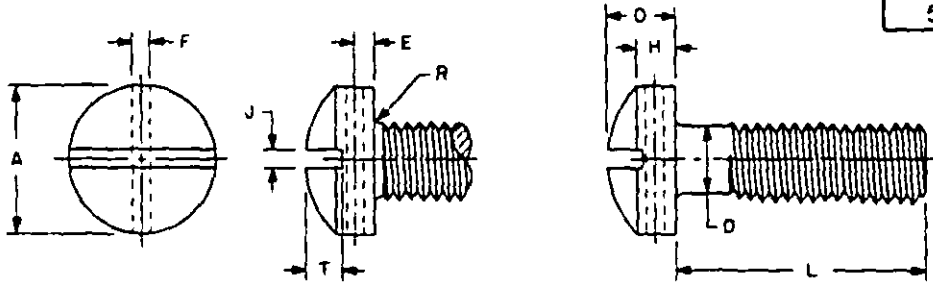


REVISION: W, IS
USER: AS, AT, MC, ME, CS, SM, W, YD



FED SUP CLASS
5305

TABLE 1

NOMINAL SIZE		.086	.112	.138	.164	.190	.250	.3125	.375
THREADS PER INCH, UNF-2A		64	48	40	36	32	28	24	24
D BODY DIAMETER	MAX	.0860	.1120	.1380	.1640	.1900	.2500	.3125	.3750
	MIN	.0733	.0954	.1184	.1424	.1654	.2225	.2806	.3430
A HEAD DIAMETER	MAX	.140	.183	.226	.270	.313	.414	.515	.622
	MIN	.124	.166	.208	.250	.292	.394	.495	.590
H HEAD SIDE HEIGHT	MAX	.062	.079	.096	.113	.130	.170	.211	.253
	MIN	.055	.072	.089	.106	.123	.163	.201	.242
O TOTAL HEAD HEIGHT	MAX	.083	.107	.132	.156	.180	.237	.295	.355
	MIN	.070	.094	.118	.143	.165	.219	.276	.333
J SLOT WIDTH	MAX	.031	.039	.048	.054	.060	.075	.094	.094
	MIN	.023	.031	.039	.045	.050	.064	.072	.081
T SLOT DEPTH	MAX	.030	.038	.045	.065	.075	.102	.130	.154
	MIN	.022	.030	.035	.054	.064	.087	.110	.134
E DRILL LOCATION	NOM	.026	.035	.043	.043	.043	.062	.078	.094
F DRILLED HOLE DIA	NOM	.031	.037	.046	.046	.046	.062	.070	.070
R RADIUS	MAX	.015	.017	.021	.025	.025	.035	.047	.056
TENSILE STRENGTH, LBS-MIN	(B)	240	400	620	900	1,240	2,250	3,600	5,430
L LENGTH	TOLERANCE	DASH NO. 1	DASH NO. 2	DASH NO. 3	DASH NO. 4	DASH NO. 5	DASH NO. 6	DASH NO. 7	DASH NO. 8
.12	+ .00 - .03	1	11	24	39	58			
.19		2	12	25	40	59			
.25		3	13	26	41	60	76		
.31		4	14	27	42	61	77	92	
.38	+ .00 - .03	5	15	28	43	61	77	92	
.44		6	16	29	44	62	78	93	
.50		7	17	30	45	63	79	94	107
.62		8	18	31	46	64	80	95	108
.75	+ .00 - .06	9	19	32	47	65	81	96	109
.84		10	20	33	48	66	82	97	110
1.00		11	21	34	49	67	83	98	111
1.25		12	22	35	50	68	84	99	112
1.50	+ .00 - .06	13	23	36	51	69	85	100	113
1.75		14	24	37	52	70	86	101	114
2.00		15	25	38	53	71	87	102	115
2.25		16	26	39	54	72	88	103	116
2.50	+ .00 - .06	17	27	40	55	73	89	104	117
2.75		18	28	41	56	74	90	105	118
3.00		19	29	42	57	75	91	106	119

(B) * Dash numbers 1 thru 57 are INACTIVE FOR NEW DESIGN AFTER 6 March 1974.

(H) FOR CHANGES SEE SHEETS 1 AND 2.

This military standard is approved for use by all Departments and Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

APPROVED 9 FEB 1954 REVISED (A) 18 JUN 1962 (B) 6 MAR 1974

P.A. NO. Other Code A2	TITLE SCREW, MACHINE-DRILLED FILLISTER HEAD, SLOTTED, ALUMINUM ALLOY, UNF-2A	MILITARY STANDARD MS 35278
PROCUREMENT SPECIFICATION FF-S-92	SUPERSEDES MS35161 in part; MS35166 in part	SHEET 1 OF 2

FED. SUP CLASS
5305

NOTES:

- 1. **MATERIAL:** Aluminum alloy, 2024, in accordance with QQ-A-200/3 or QQ-A-225/6. The minimum ultimate tensile strength shall be 62,000 PSI.
- 2. **PROTECTIVE COATING:** Anodized in accordance with MIL-A-8625, Type I or II, Class 1.
- 3. **THREADS:** The threads shall be in accordance with Screw-Thread Standards for Federal Services, Handbook M28.
- 4. **DIMENSIONS:** All dimensions in Table I are in inches.
- 5. **PART NUMBER:** The MS part number consists of the MS number, plus the dash number.
Example: MS3527R-55.
- 6. **THREAD LENGTH:** Full form threads shall extend to within 2 threads or less of head bearing surface for lengths thru 2.00 inches/50.80 millimetres. Longer lengths shall have a minimum full form thread length of 1.50 inches/38.10 millimetres.
- 7. The drilled hole shall be approximately at a right angle to the slot and may be permitted to break through the bottom of the slot. All burrs and sharp edges shall be removed.
- 8. Referenced documents shall be of the issue in effect on date of invitations for bid.
- 9. For design feature purposes, this standard takes precedence over procurement documents referenced herein.

TABLE II
METRIC TRANSLATION OF TABLE I

NOMINAL SIZE		2.18	2.94	3.51	4.17	4.83	6.35	7.94	9.52
THREAD PITCH		.40	.53	.64	.71	.79	.91	1.06	1.06
D BODY DIAMETER	MAX	2.18	2.84	3.51	4.17	4.83	6.35	7.94	9.52
	MIN	1.86	2.42	3.01	3.62	4.21	5.65	7.13	8.71
A HEAD DIAMETER	MAX	3.56	4.65	5.74	6.86	7.95	10.52	13.16	15.80
	MIN	3.15	4.22	5.28	6.35	7.42	9.08	12.45	14.99
H HEAD SIDE HEIGHT	MAX	1.57	2.01	2.44	2.87	3.30	4.32	5.36	6.43
	MIN	1.40	1.83	2.26	2.69	3.12	4.09	5.13	6.15
C TOTAL HEAD HEIGHT	MAX	2.11	2.72	3.33	3.96	4.57	6.02	7.49	9.02
	MIN	1.78	2.39	3.00	3.58	4.19	5.56	7.01	8.46
J SLOT WIDTH	MAX	.79	.99	1.22	1.37	1.52	1.90	2.13	2.39
	MIN	.58	.79	.99	1.14	1.27	1.63	1.83	2.06
T SLOT DEPTH	MAX	.76	.97	1.14	1.65	1.90	2.59	3.10	3.91
	MIN	.56	.76	.89	1.37	1.63	2.21	2.79	3.40
E DRILL LOCATION	NOM	.66	.89	1.09	1.09	1.09	1.57	1.98	2.39
F DRILLED HOLE DIA	NOM	.79	.94	1.17	1.17	1.17	1.57	1.78	1.78
R RADIUS	MAX	.33	.43	.53	.64	.71	.97	1.19	1.42

L LENGTH	TOLERANCE	DASH NO.*	DASH NO.*	DASH NO.*	DASH NO.*	DASH NO.	DASH NO.	DASH NO.	DASH NO.
3.05		1	11	24	39				
4.83		2	12	25	40	58			
6.35		3	13	26	41	59			
7.97		4	14	27	42	60	76		
9.66	+.00	5	15	28	43	61	77	92	
11.18	-.76	6	16	29	44	62	78	93	
12.70		7	17	30	45	63	79	94	107
15.75		8	18	31	46	64	80	95	108
19.05		9	19	32	47	65	81	96	109
22.35		10	20	33	48	66	82	97	110
25.40		11	21	34	49	67	83	98	111
31.75	+.00	12	22	35	50	68	84	99	112
38.10	-1.52	13	23	36	51	69	85	100	113
44.45				37	52	70	86	101	114
50.80				38	53	71	87	102	115
57.15	+.00				54	72	88	103	116
63.50	-2.29				55	73	89	104	117
69.85					56	74	90	105	118
76.20					57	75	91	106	119

* Dash numbers 1 thru 57 are INACTIVE FOR NEW DESIGN AFTER 6 March 1974.

This military standard is approved for use by the Department of Defense. Selection of this standard for repetitive use shall be made from this document.

REVIEWER: AV, IS
USER: AS, AI, MC, ME, OS, SH, WY, YD

APPROVED 9 FEB 1954 REVISED 18 JUN 1962 FOR CHANGES SEE SHEETS 1 AND 2.

P.A. WC Other Case 82	TITLE SCREW, MACHINE-DRILLED FILLISTER HEAD, SLOTTED, ALUMINUM ALLOY, UNF-2A	MILITARY STANDARD MS 35278
PROCUREMENT SPECIFICATION FF-S-92	SUPERSEDES: MS35361 in part; MS35366 in part	SHEET 2 OF 2

FOLD

POSTAGE AND FEES PAID
DEPARTMENT OF THE ARMY
DOD - 314



OFFICIAL BUSINESS
PENALTY FOR PRIVATE USE \$300

Commander
Rock Island Arsenal
ATTN: SARRI-LE-SC
Rock Island, Illinois 61201

FOLD

STANDARDIZATION DOCUMENT IMPROVEMENT PROPOSAL		OMB Approval No. 22-R255
<p>INSTRUCTIONS: The purpose of this form is to solicit beneficial comments which will help achieve procurement of suitable products at reasonable cost and minimum delay, or will otherwise enhance use of the document. DoD contractors, government activities, or manufacturers/vendors who are prospective suppliers of the product are invited to submit comments to the government. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements. Attach any pertinent data which may be of use in improving this document. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity.</p>		
DOCUMENT IDENTIFIER AND TITLE <u>MS3527 Rev B, Screw, Machine-Drilled Fillister Head, Slotted, Aluminum Alloy, UNF-2A</u>		
NAME OF ORGANIZATION AND ADDRESS		CONTRACT NUMBER MATERIAL PROCURED UNDER A <input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT
<p>1. HAS ANY PART OF THE DOCUMENT CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE?</p> <p>A. GIVE PARAGRAPH NUMBER AND WORDING.</p> <p>B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES</p>		
2. COMMENTS ON ANY DOCUMENT REQUIREMENT CONSIDERED TOO RIGID		
3. IS THE DOCUMENT RESTRICTIVE? <input type="checkbox"/> YES <input type="checkbox"/> NO (If "Yes", in what way?)		
4. REMARKS		
SUBMITTED BY (Printed or typed name and address - Optional)		TELEPHONE NO. DATE